

GRIDUCT 3

IDENTIFICATION: GRIDUCT 3 E8018B2

CLASSIFICATION: AWS/SFA 5.5: E8018B2, IS 1395: E 55B- 226Fe, BS: 2493E1CrMoBH, DIN 8575-84 ECrMo1B20+

CHARACTERISTICS:

A heavy coated, low hydrogen, all position, except vertical down, Synthetic electrode which deposits 1.25% Cr/ 0.5% Mo weld metal. It is intended for welding creep resisting steels of similar composition, used in power generating plant operating at temperatures upto 570°C. The welds are of X-ray quality.

WELD METAL ANALYSIS (%)

C	Mn	Si	Mo
0.05-0.12	0.5-0.9	0.2-0.6	0.4-0.65
S	P	Cr	
0.025 max	0.03 max	1.0-1.50	

TYPICAL APPLICATIONS

- ASTM A 335 grades P11 and P12
- ASTM A 155 grades ½ C, 1 Cr, 1 ¼ Cr, A 182F11, DIN 13 CrMo44 ,GS-17CrMo55,BS 3604 grades 620 and 621.
- Ideal for welding Chromium-Molybdenum alloy steels (0.5Cr-0.5Mo, 1cr-0.5 Mo, 1.25Cr-0.5Mo),
- Boilers, pressure vessels, headers, high pressure piping, heat exchangers and condensers.
- Power generation, oil refineries, petrochemical industries.

Mechanical Properties of the Weld Metal (AFTER PWHT AT 690°C ± 14°C/1HR)

UTS (MPa)	YS (MPa)	ELN (%) (L=4D)	CVN Impact value		Fillet Weld test
			Temp	Joule	
550-690	460-590	19-26	27°C	55-100	Satisfactory

ASME QUALIFICATION: QW-432 F.NO4, QW-442 A NO.4

RECOMMENDED REDRYING: 300°C/2 hrs, (Max. 5 times, total 10 hrs max.)

MOISTURE IN THE FLUX COATING: 0.3% by weight, maximum

DIFFUSIBLE HYDROGEN CONTENT IN THE WELD METAL: Max 5 ml/100g.of weld metal

RECOMMENDED PREHEATING & INTERPASS TEMPERATURE: 163°C-191°C

MICROSTRUCTURE: After PWHT, the micro structure consists of tempered bainite.

RECOMMENDED CURRENT AND PACKING DATA:

Size (mm)	Length (mm)	AMPS AC(70V)/DC(+)	Quantity/Box (PCS)
2.5	350	60-80	160x4=640
3.15/3.20	450	90-130	110x4=440
4.0	450	140-190	70x4=280
5.0	450	190-250	45x4=180

Manufactured by: GEE LIMITED

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